


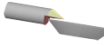





Recess Tool with Cyl. Grinding Ø8 Z1

A17-010

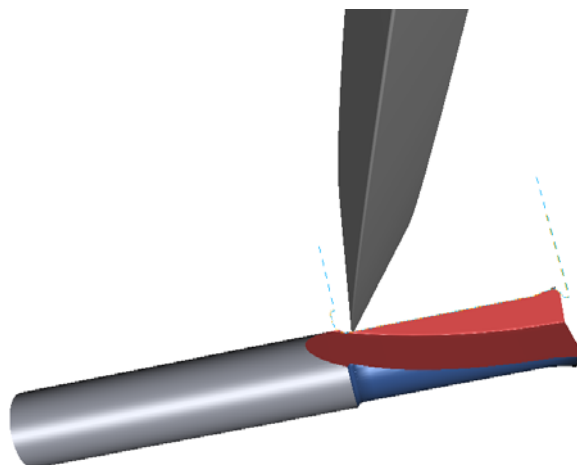
The A02-001 Application allows to execute a DXF-profile grinding process in a cylindrical grinding mode - typically used for the production of ID turning tools. Designed as shown in the pictures the tool can be resharpened over 120°.



1. Cycletime for Production

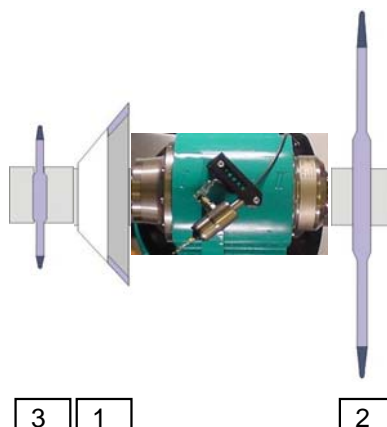
Workpiece: Ø 8mm, Z1, L=25 mm Material CARBIDE				
Operations				
Feed [mm/Min]	2000	5	4	2
Power [kW]		2	4	4
Cutting speed [m/s]		22	24	24
Used wheels				
Grinding time [s]	20	120	411	959
Total cycle time	25 Min 10			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	12V9 Ø125 D64
2	14EE1 Ø200 D64
3	14EE1 Ø40 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 31i

Accessories:

Responsible engineer: LLU, 02.04.2013

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China